



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4894-3

Job Sheet 183260



Part No: D4894-3

Job Qty: 1 ea *274*

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 2 IPP REV:B 13.05.27 AS PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Waterjet		<i>OK 18/10/16</i>
100	Waterjet	1 pcs	10/5/18	10/5/18	0.00	2.72	Waterjet1 <i>OMAX</i>		<i>OK 18/10/16</i>
110	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Waterjet-1		<i>OK 18/10/16</i>
114	Mill Conv	1 pcs	10/5/18	10/5/18	0.00	1.28	Mill Conv 1		<i>18/10/16</i>
116	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-3		<i>18/10/16</i>
120	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		<i>18-11-09</i>
130	HandFinish	1 pcs	10/5/18	10/5/18	0.00	0.25	HandFinish1		<i>18/11/05</i>
140	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		<i>18-11-5</i>
141	Powdercoat	1 pcs	10/5/18	10/5/18	0.00	0.17	Powdercoat1		<i>18-11-09</i>
142	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC3		<i>NOV 09 2018</i>
145	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC5	<i>DAS</i>	<i>NOV 09 2018</i>
150	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2	<i>6</i>	<i>NOV 09 2018</i>
160	QC21-SA	1 Ea	10/5/18	10/5/18	0.00	0.00	QC21	<i>2-89</i>	<i>NOV 09 2018</i>

Part Op 100 - 1-Cut as per Dwg Dwg Rev: *B* Prog Rev: *B* 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

114 - DRILL HOLES AS PER DWG

116 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC7-Inspect Chemical Conversion Coat

141 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MASK AS PER NOTE 8 START TIME: *8:25* OVEN

TEMPERATURE: *300* FINISH TIME: *8:35*

142 - QC3- Inspect Part Finish

145 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	4.5850 ft (4.585 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	5	50	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Part Specifications

Specifications could not be found.

Plex 9/14/18 10:28 AM Dart.lajeunesse.marie

DART
AEROSPACE

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CANADA
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www.dartaerospace.com

Container No: S119044



Part: D4894-3

Job No: 183260

Serial No/Batch: S119044

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/17/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 183260
Description: Aft Beam		Part Number: D4894-3
Inspection Dwg: D4894	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
55.02	+/-0.030	55.02	1		Tap	
19.63	+/-0.030	19.63	1		Viper-02	
7.38	+/-0.030	7.38	1			
10.61	+/-0.030	10.61	1			
5.25	+/-0.030	5.25	1			
8.25	+/-0.030	8.25	1			
1.50	+/-0.030	1.499	1			
3.50	+/-0.030	3.507	1			
0.65	+/-0.030	0.656	1			
9.56	+/-0.030	9.56	1			
4.65	+/-0.030	4.65	1			
28.80	+/-0.030	28.80	1			
7.16	+/-0.030	7.16	1			
4.47	+/-0.030	4.47	1			
1.00	+/-0.030	0.999	1			
3.50	+/-0.030	3.499	1			
0.75	+/-0.030	0.750	1		Boomer JUDS	
1.800 Pitch	+/-0.005	1.799	1		"	
3.600	+/-0.005	3.600	1		"	
0.60	+/-0.030	0.601	1		"	
2.300	+/-0.005	2.300	1		"	
Ø0.377	+0.006/-0.001	0.377	1		"	
2.00	+/-0.030	2.00	1		"	
0.60	+/-0.030	0.600	1		"	
Ø0.129	+0.005/-0.001	0.129	1		"	

Measured by: DA	Audited by: VEX	Preliminary Approval:
Date: 18/10/16	Date: 2018-11-24	Date:

Rev	Date	Change	Revised by	Approved
A	14.11.13	New Issue	KJ	

